

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000758**Date Inspected:** 16-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** SHanghai, China

Witness: **Procedure Qualification Record**
Welding **NDT**

Welder Qualification **Fracture Critical**
Mechanical Testing, describe:Brack test

Index Lot #:**Witness Lot #:** B240-039-10**Bridge No:** 34-0006**Component:** SF2-2F**Welder:** Zhai Qing Hua**ID #:****Joint Description:** T-joint

N/A

WPS ID #:

WPS-B-P2112

N/A

Base Metal: A709m-345

N/A

PQR ID #:

N/A

Thickness: 12mm

N/A

Process:

SMAW

N/A

Electrode Spec/Class: E7018

N/A

Positions:

2F

N/A

Backing Material:

N/A

CWI:

Li Yan Hue (07120701)

N/A

Average Amps: 90~130

N/A

AWS Code:

D1.5 2002

N/A

Average Volts: 18~24

N/A

Applicable Sec:

section 5

N/A

Travel Speed: 28~134

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

Caltrans QA inspection Mr. Wai Pau witnessed welder qualification test at bay #10. The welder qualification test utilizing the SMAW process was conducted by Mr. Zhai Qing Hun performed in tack weld flat position (2F). After welding completion, the break test performed by the ZPMC CWI Mr. Li Yan Hue (07120701). The welder qualification test was appeared to be in general compliance with requirements of AWS D1.5 2002 section 5.

Summary of Conversations:

As notes within report above.

is in general conformance with the contract requirements.

Observed welding,testing or results:

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784 , who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

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Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
